

Thursday, 3/2/2006 3:07:29 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 26027

: 10195

P.O. Number

: NIA

This Issue Prsht Rev. : 3/2/2006

: NC

: NIA

: NIA

Type

S.O. No. : NA

: MACHINED PARTS

Part Number **Drawing Number**

Drawing Name

: D21741

: WEB

. D2174-1 REV. D : N/A

Project Number Drawing Revision

: D

Material **Due Date**

: WA : 3/25/2006

Qtv:

40 Um:

Each

Written By

First Issue

Previous Run

Checked & Approved By

Comment

: Est C 04.06.09

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

2024-T3 .063 sheet

M2024T3S063

Comment: Qty.:

0.4958 sf(s)/Unit Total: 19.8324 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: <u>M19059</u>

2.0 SHEAR

Comment: SHEAR

Cut blank: 12.75" x 4.83"

Grain along 12.75"

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA097 and Dwg D2174

Stack of 10.

Identify as D2174-1

INSPECT PARTS AS THEY COME OFF MACHIN

4.0

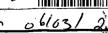
Comment: INSPECT PARTS AS THEY COM نر@FF MACHINE

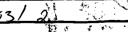


Comment: SECOND











Dart A	erospace	Ltd
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W /O:		11.	W	ORK ORDER CHA	NGES	· ·			
DATE	STEP	-	PROCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PA	R #: Fault Cate	aorv.	NCR: Yes	No DO	A: 9	Date:	610406

				***	QA: N/	C Closed:	Date: _		
NCR:			WORK ORD	ER NON-CONFORMANO	CE (NCR)				
D. 47F	0755	Description of NC		Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	gn & Section C	Approval Chief Eng	QC Inspector
		<i>2</i> .							
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NOTE: Date & initial all entries

Thursday, 3/2/2006 3:07:29 PM Date: Úser: Kim Johnston **Process Sheet Drawing Name: WEB** Customer: CU-DAR001 Dart Helicopters Services Part Number: D21741 Job Number: 26027 Job Number: Seq. #: Description: Machine Or Operation: SMALL & MEDIUM FAB RESOURCE 1 6.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 YO. Deburr Stack QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 8.0 HAND FINISHING Comment: HAND FINISHING RESOURCE #1 <u>5140</u> Chemical Conversion Coat as per QSI 005 4.1 9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT CHEMICAL CONVERSION COAT 10.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 11.0 DOCUMENT CONTROL Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Aerospace I	Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE By Date							Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCI					
NCR:			WORK ORDE	R NON-CONFORM	MANCE			d:	Date: _	
				Corrective Action Se	ection B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		Verification Section C		Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26027
Description: Web	Part Number:	D2174-1
Inspection Dwg: D2174 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.249	_			
6.400	+/-0.010	6.401				
4.800	+/-0.010	4.797				
1.375	+/-0.010	1.376	~			
1.050	+/-0.005	1.050				
Ø0.128	+0.005/-0.000	\$0.132	_			
12.650	+/-0.010	12.650				
0.550	+/-0.010	0.555				
0.900	+/-0.010	0,900				
1.629	+/-0.010	1.625	_			
1.506	+/-0.005	1.505				
11.550	+/-0.005	11.550	-			
50°	+/-0.5°	500				
0.063 thick	+/-0.010	0,064				
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Measured by:	The	Audited by:	Prototype Approval:	N/A
Date:	06/03/18	Date: 06.03.18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.12	New Issue	KJ/JLM	

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DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. 04.06 6.250 3.012 (1.506 PITCH) 1.629 CHECKED RO.13 04.06.03 4.283 4.800 O O œ ➣ 0.500 R0.35 (TYP) GRAZN DORECTION 2.692 50 (TYP) 0.900 0.821 00.09.11 96.01.18 95.10.25 04.06.03 Ø0.128 (26 PLS) /B 1.375 1.075 10.500 (1.050 PITCH) 0.550 11.550 (1.050 PITCH) WEB DRAWING NO. D2174-1 NEW RE-DESIGN UPDATE FINISH SPEC RE-DRAWN CHANGE D2174-1 ISSUE DAR. RT AEROSPACE L NOTES: MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL SHARP EDGES 0.005 TO 0.010

ACCOUNTROLLED

CONTROLLED

CON DIMENSION ANY ASSISTACT TO AMENDME S PURPOSE OR WITHOUT NOTICE WORK ORDER SHEET 0 COPIED 1 OF 1 REV.

